

Work Order ID 56406

February 23, 2010 8:33:36 AM



Page 2

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 2/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

110

Operation
Description

HandFinishing

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

HandFinish

Memo

0.00

*****Do not apply LPS, see QC for more info*****

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 _____

2-Install tubes together and seal them all the way around using Sikaflex
241/291. Ensure tube ends line-up with saddle holes for proper alignment. using
7/16" "T" Pins.A/R Sikaflex-241/291 112345.Expiry date: 10/083-Install wearplates as per Dwg D3391. Ensure that plastic washers are against
wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten
only bolts with no sikaflex.A/R LPS Procyon. 104/251A/R Sikaflex-241/291 112.345.Expiry date: 10/08

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with
MEK degreaser.

P TO
BL 10-07-2t.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-742-043 PAR #: Fault Category: Finishing NCR: Yes No DQA: Date: 10/03/16
 Resolution: re-work Disposition: re-work QA: N/C Closed: Date: 10/03/16

NCR: 56406		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.02.24	110	Saddle holes don't allow passage of pin. (1) Hole Affected. R.C. Process	<u>JP</u> 10.02.24 per QSI 042	File inner hole to allow passage of pin	<u>BR</u> 10.02.24 S 10.02.24	<u>JP</u> 10.02.24 per QSI 042	<u>S</u> 10.02.24	

NOTE: Date & initial all entries

Work Order ID 56406

February 23, 2010 8:33:40 AM



Page 3

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 2/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

QC5- Inspect part completeness to step on W/O

0.00

⇒ 8/10/2010

(70)

Quality Control

Memo

0.00

130



Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

PPN 34757

10/03/10 6

140



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

10/03/05 10
MF
10-3-4

Picklist Print

February 23, 2010 8:33:12 AM

Page 1

8

Work Order ID: 56406



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 2/23/10

Required Date: 2/24/10

Comments: IPP Rev A 05.10.13 New Issue

KJ/JLM

Start Qty: 1.00

IPP Rev B 06.02.13 ECN 773 dwg @ rev.D

EC

Required Qty: 1.00

IPP Rev:C 07-05-28 As per Rev F

JLM

IPP Rev:D 07-12-04 ECN 1072

DD verified by:JLM

AN3C4A

Purchased

No

110

Each

1,107.000 24.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	1107	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	64	
113226	344	
113644 ✓	468	
113749	200	

24. Bk 10-02-24.

AN3C6A

Purchased

No

110

Each

766.0000 12.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	766	
111982 ✓	766	

12 Bk 10-02-24.

Picklist Print

Page 2

February 23, 2010 8:33:13 AM

Work Order ID: 56406



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 2/23/10

Required Date: 2/24/10

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev:C 07-05-28 As per Rev F
IPP Rev:D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

AN3C7A



Purchased

No

110

Each

517.0000

8.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	517	
105906	21	
107376	252	
113149	244	

8. BL 10-02-24

AN960C10L



Purchased

No

110

Each

388.0000

44.0000



washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

OFFSHORE
FG 113288

103585	100	
--------	-----	--

44 BL 10-02-24

Main Warehouse

ST	288	
112116	128	
112612	160	

D3391-021



Fwd Tube Assembly

Manufactured

No

110

Each

0.0000



Weld on
D3391-021
B6.0A28/N
10-3-4
MF 53494

February 23, 2010 8:33:13 AM

Shop Packet Print

Page 2

Picklist Print

February 23, 2010 8:33:13 AM

Page 3

Work Order ID: 56406



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 2/23/10

Required Date: 2/24/10

Comments: IPP Rev A 05.10.13 New Issue. KJ/JLM
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
IPP Rev:C 07-05-28 As per Rev F JLM
IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

D3391-023



Manufactured No

110

Each

2.0000

1.0000



Mid Tube Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

53938

2

1

BR 10-02-23.

40522

1

54395

1

D3391-025



Manufactured No

110

Each

3.0000

1.0000



Aft Tube Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

3

39129

1

48122

1

54702

1

54703

1

BR 10-02-03.

Picklist Print

Page 4

February 23, 2010 8:33:13 AM

Work Order ID: 56406



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 2/23/10

Required Date: 2/24/10

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM

Start Qty: 1.00

IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC

IPP Rev:C 07-05-28 As per Rev F JLM

IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM

D3564-1



Manufactured No

110

Each

21.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	_____
33798	2	_____
Main Warehouse		
ST	19	_____
47531	1	_____
50270	1	_____
51676✓	17	1 BL 10-02-24.

Picklist Print

Page 5

February 23, 2010 8:33:14 AM

Work Order ID: 56406



Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 2/23/10

Required Date: 2/24/10

Comments: IPP Rev A 05.10.13 New Issue

KJ/JLM

Start Qty: 1.00

Required Qty: 1.00

IPP Rev B 06.02.13 ECN 773 dwg @ rev.D

EC

IPP Rev:C 07-05-28 As per Rev F

JLM

IPP Rev:D 07-12-04 ECN 1072

DD verified by:JLM

D3564-3

Manufactured No

110

Each

22.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
OFFSHORE			
	FG	2	
	33764	2	
Main Warehouse			
	FP	8	
	50113	8	1 BL 10-02-24.
Main Warehouse			
	FP19	11	
	55489	11	
Main Warehouse			
	ST	1	
	46445	1	

Picklist Print

Page 6

February 23, 2010 8:33:14 AM

Work Order ID: 56406



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 2/23/10

Required Date: 2/24/10

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev:C 07-05-28 As per Rev F
IPP Rev:D 07-12-04 ECN 1072

KJ/JLM

EC

JLM

DD verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-5



Manufactured No

110

Each

43.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	39	
51925	1	
54772	13	
55024	12	
55333	13	
Main Warehouse		
ST	2	
45824	1	
47433	1	

1 bl 10-02-24,

Picklist Print

Page 7

February 23, 2010 8:33:15 AM

Work Order ID: 56406



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 2/23/10

Required Date: 2/24/10

Comments: IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D
IPP Rev:C 07-05-28 As per Rev F
IPP Rev:D 07-12-04 ECN 1072

KJ/JLM
EC
JLM
DD verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-1



Manufactured No

110

Each

37.0000 2.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	32	
52512	3	
54480	1	
55011	1	
55320 ✓	27	2 BL 10-02-24.
Main Warehouse		
ST	5	
46349	1	
51218	1	
51259	3	

February 23, 2010 8:33:15 AM

Shop Packet Print

Page 7

Picklist Print

Page 8

February 23, 2010 8:33:16 AM

Work Order ID: 56406



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 2/23/10

Required Date: 2/24/10

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM :
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
IPP Rev:C 07-05-28 As per Rev F JLM
IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-5



Manufactured No

110

Each

33.0000 1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

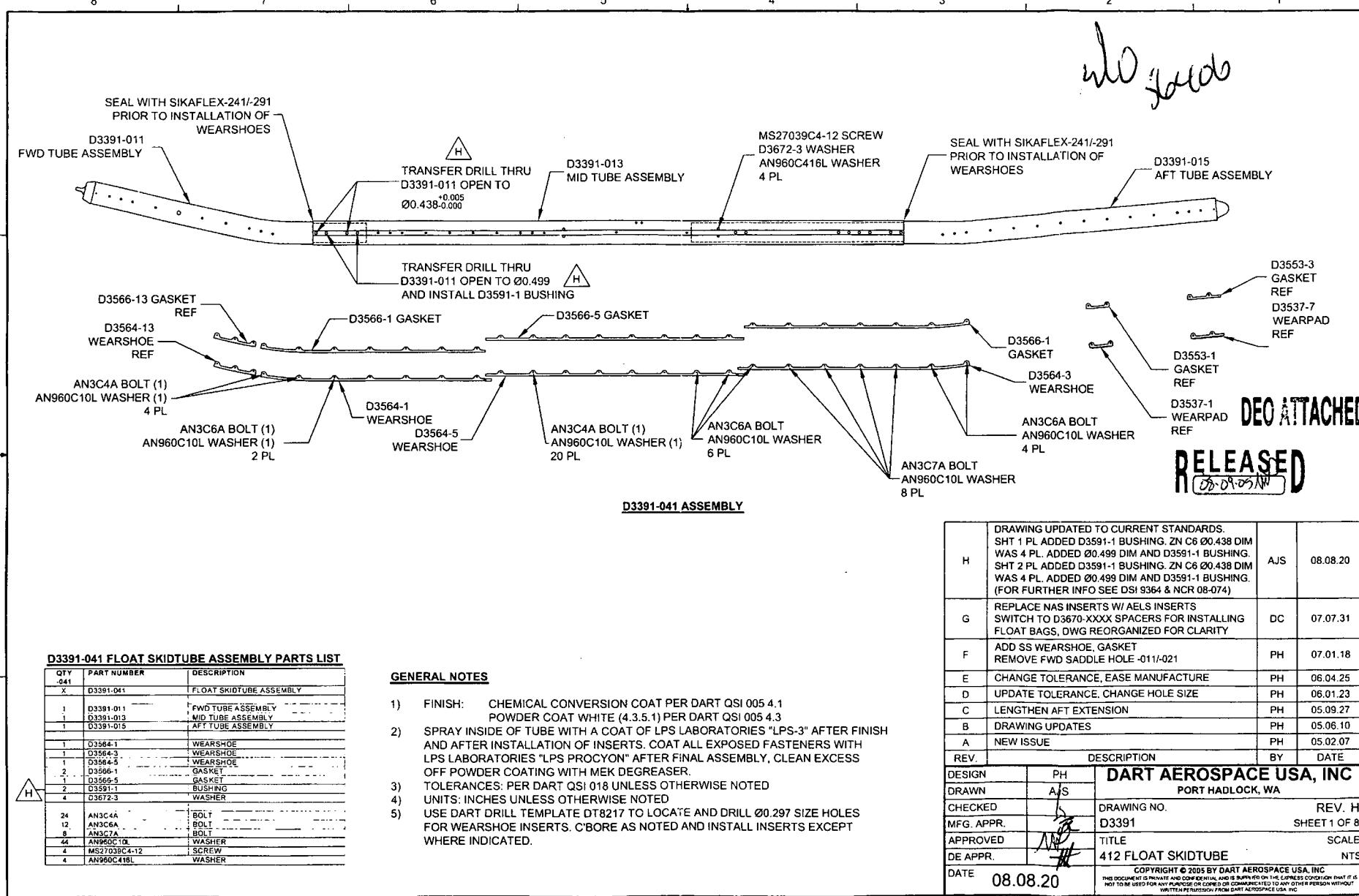
Main Warehouse

FP19	29	
55026	17	
55335	12	

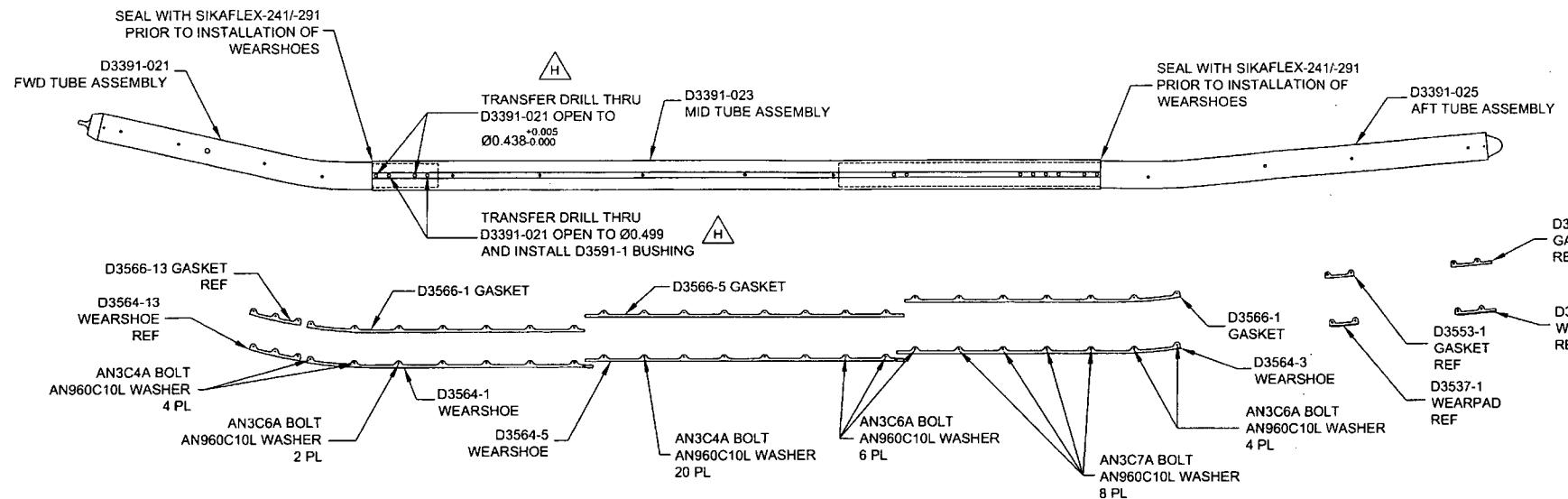
10-02-24.

Main Warehouse

ST	4	
36113	1	
46186	1	
47318	1	
51260	1	



REV 5/20/05



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
.043	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
1	D3566-1	GASKET
2	D3566-5	GASKET
1	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

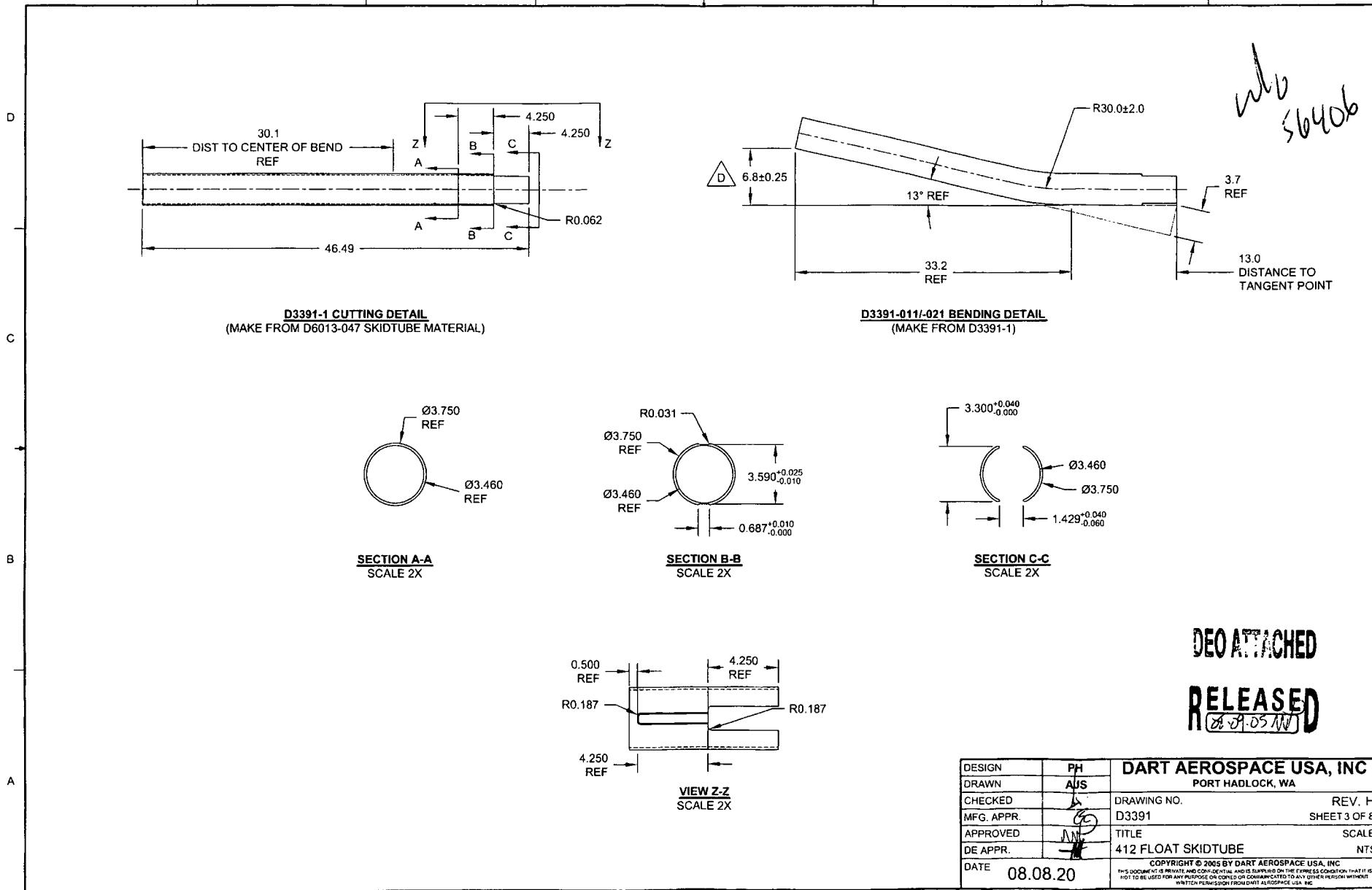
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RELEASED
08.08.20

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE 08.08.20			

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8 7 6 5 4 3 2 1



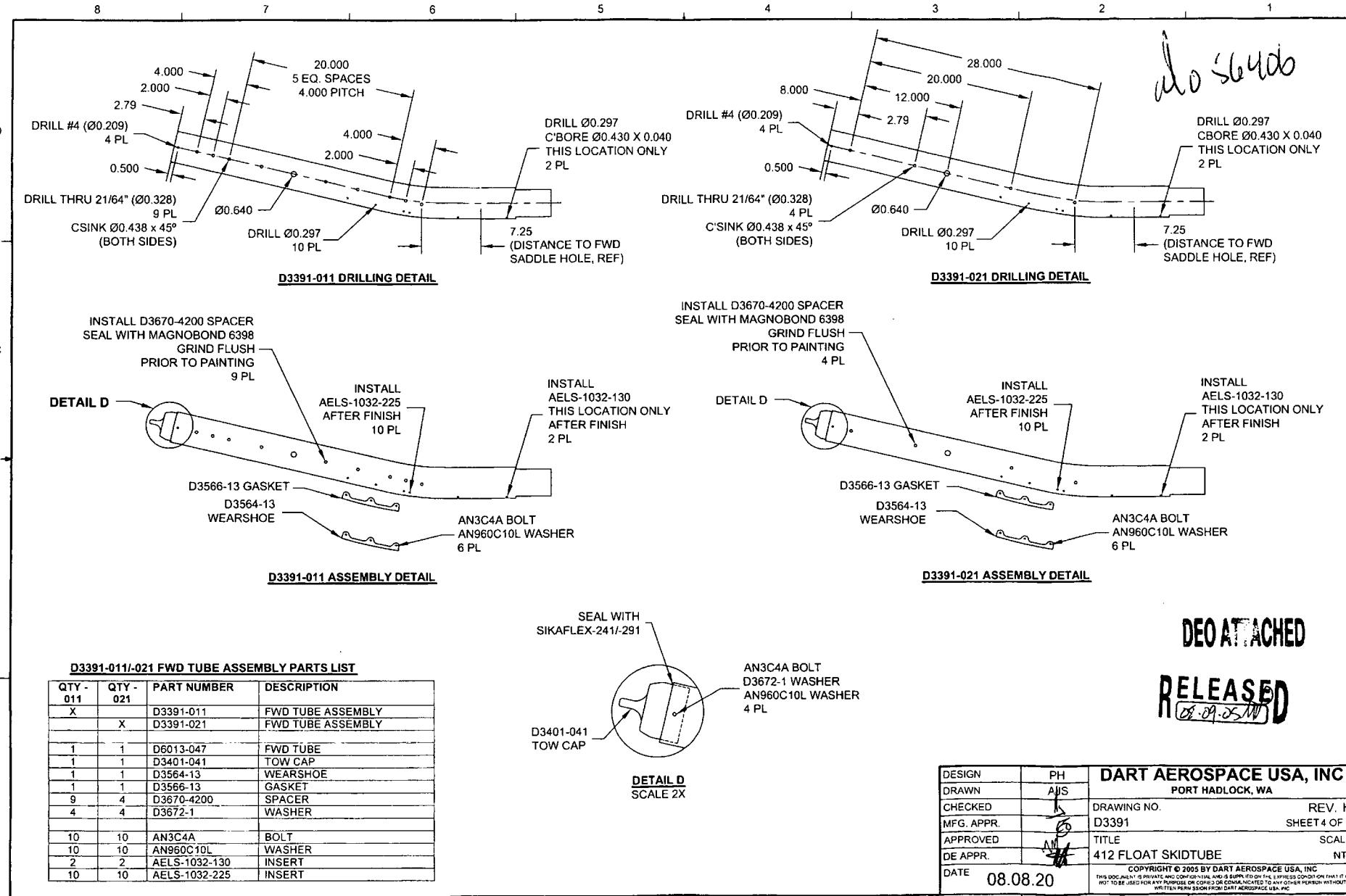
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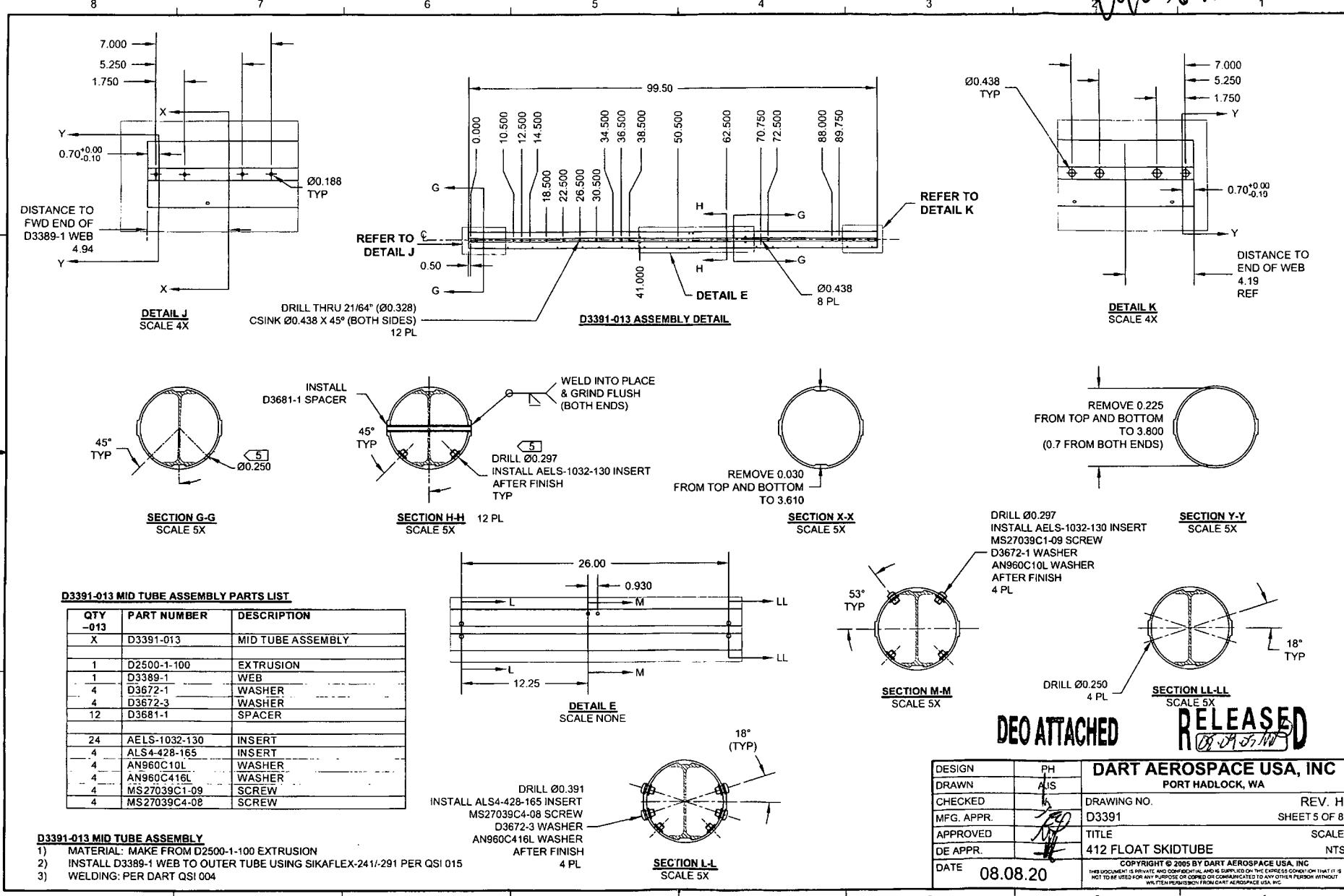
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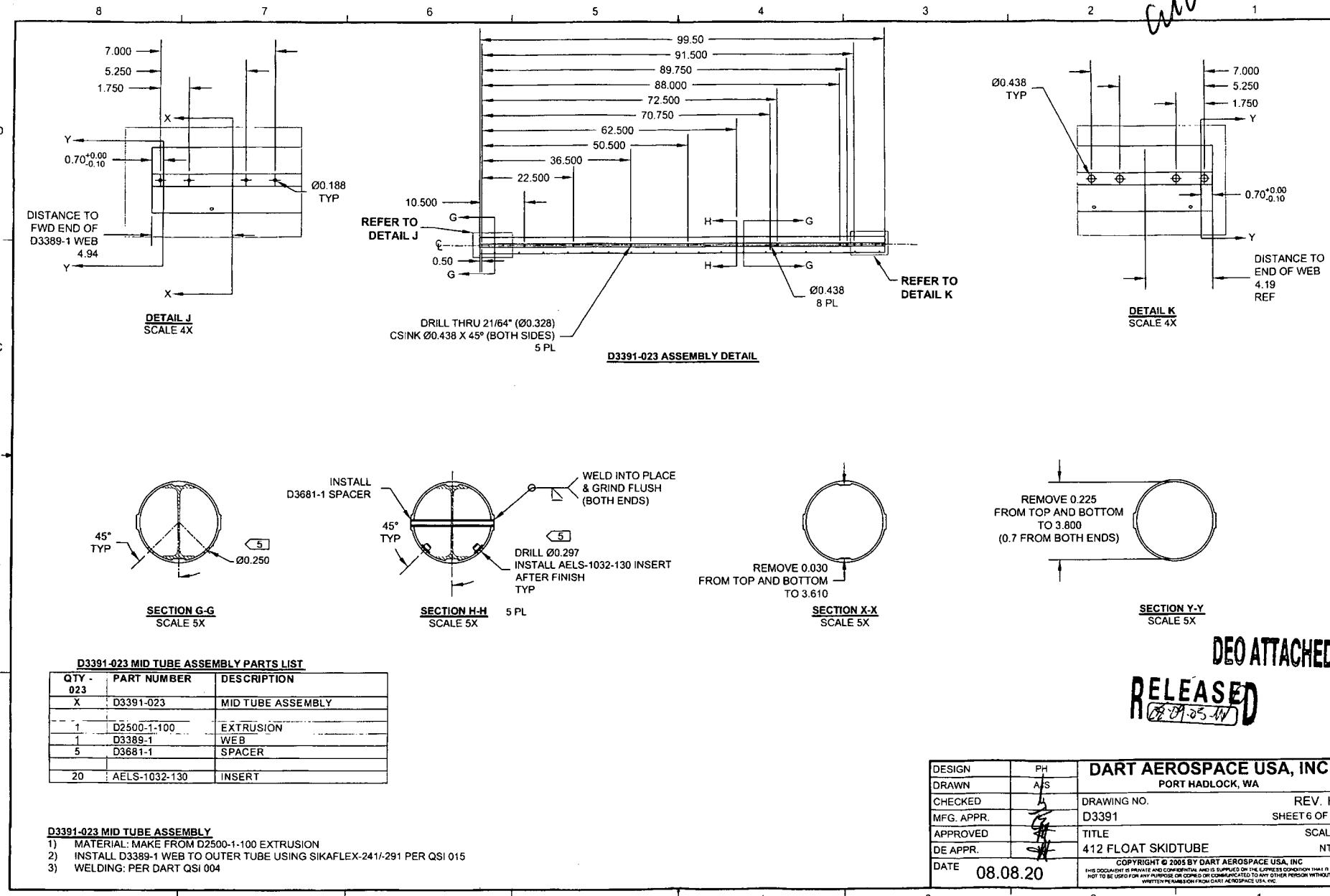
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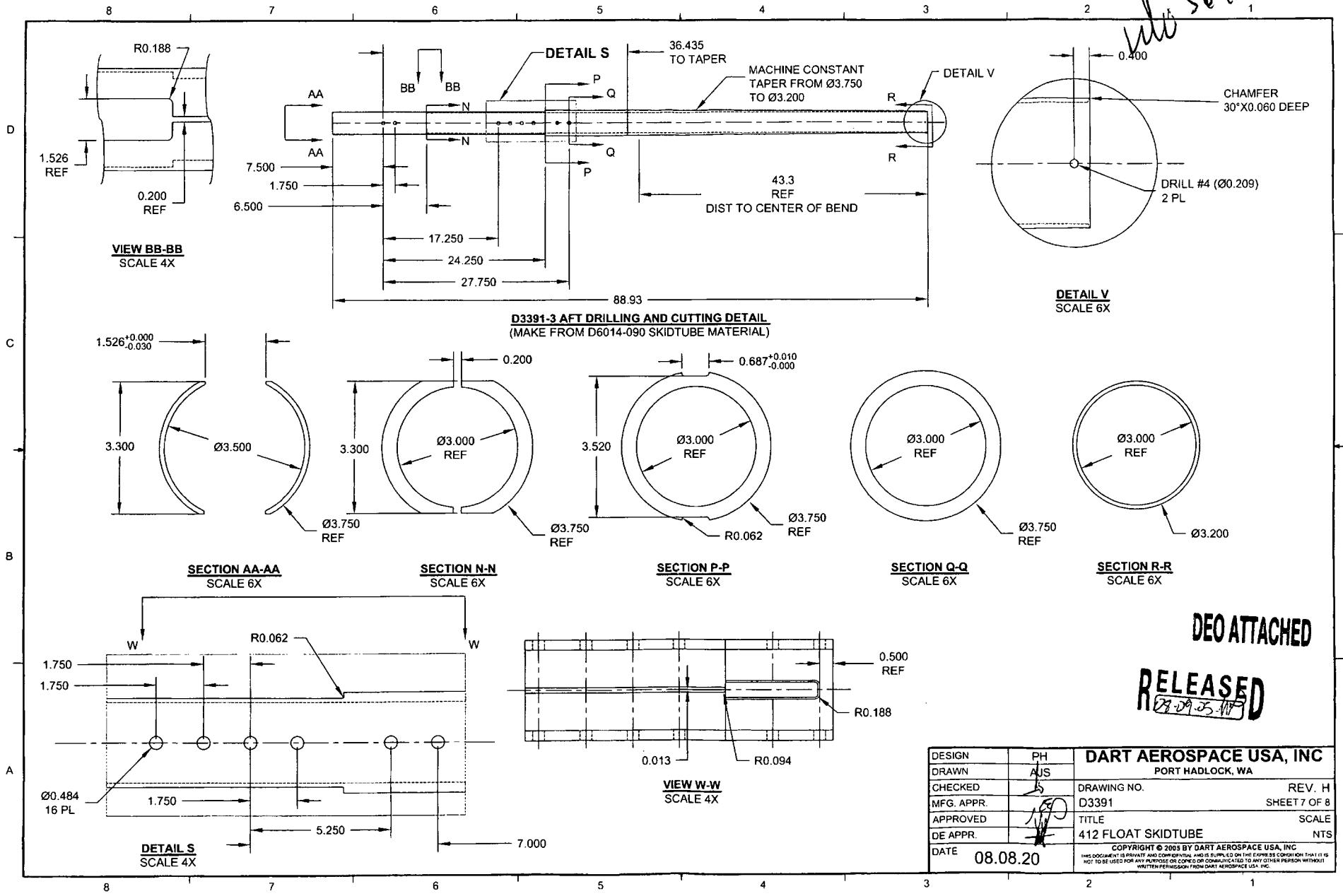






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 08.08.20

105640b

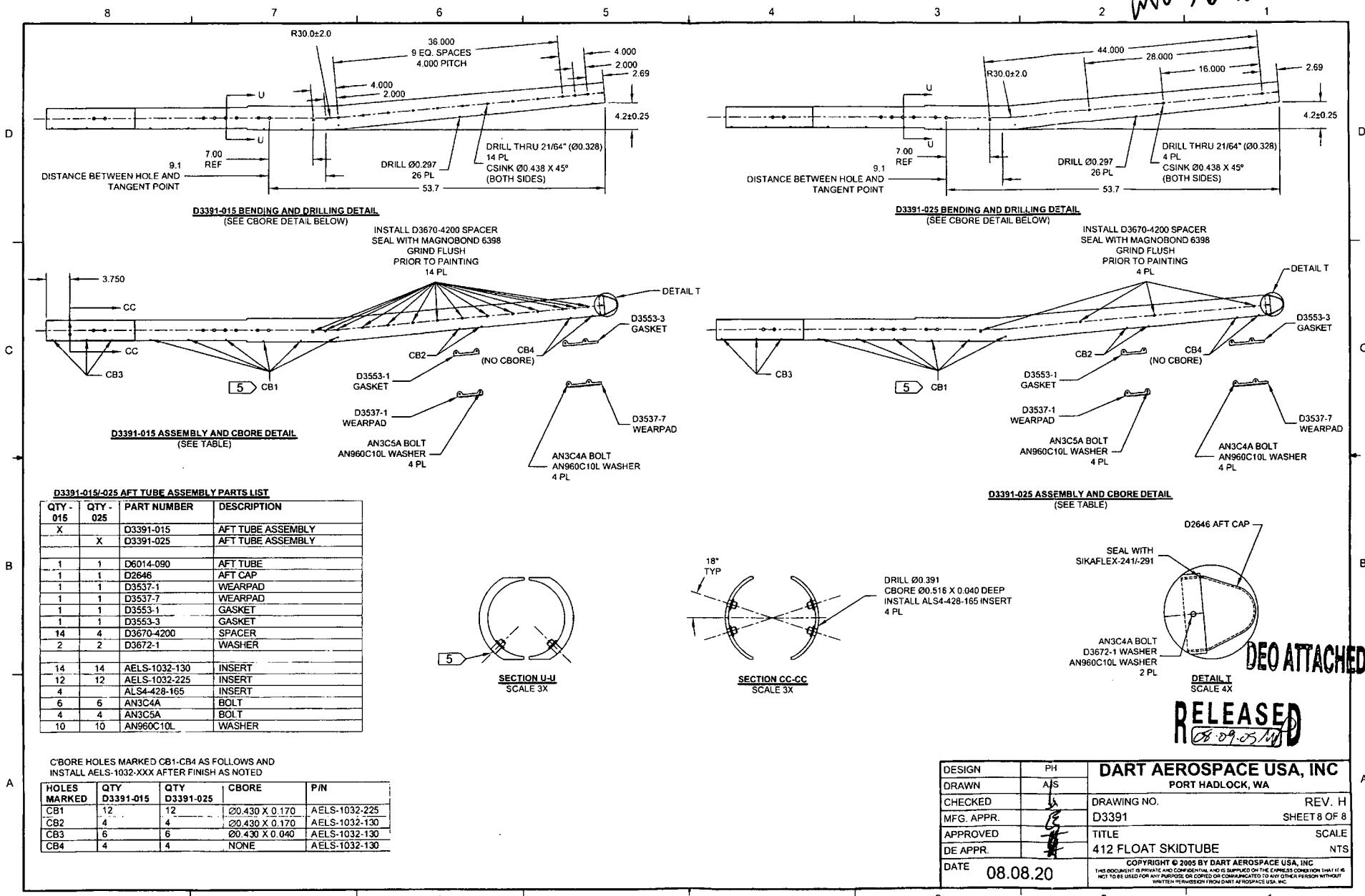


DEO ATTACHED

RELEASED
28-09-05 117

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<u>S</u>	DRAWING NO.	REV. H
MFG. APPR.	<u>S</u>	D3391	SHEET 7 OF 8
APPROVED	<u>W</u>	TITLE	SCALE
DE APPR.	<u>W</u>	412 FLOAT SKIDTUBE	NTS
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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>J</i>		MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>	DE APPR. <i>HP</i>	
DATE 09.09.23	DATE 09.09.24		DATE 09/09/25	DATE 09/09/30	DATE 09/09/30	

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
2010-02-02

MP

WMO 1640b